

Work Order ID 119740

May-21-14 9:18:59 AM

Friday 23/05

Page 1

Item ID: D3910-7  
Revision ID: PRELIM  
Item Name: Crosstube Lug

*See EDR*  
*Strelak*  
**PRELIMINARY ISSUE**  
*Accept*

\*119740\*

\*N900040100\*

Setup Start \*NS1\*  
Stop \*NS2\*

Start Date: 5/21/14 Start Qty: 10.00 \*10\*  
Required Date: 5/22/14 Req'd Qty: 10.00 \*10\*

Cust Item ID:  
Customer:

Reference:

Approvals: Process Plan: *W* Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*  
Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3910	<i>PE1</i> <i>See E</i>

110	Outsource process - Machining	0.00
*110*	HAAS CNC VERTICAL MACHINING #1	
Outsource5	Memo	0.00
Outsource process - Machining	Issue P/O to Metec : <i>24278</i>	
	Machine as per dwg	
	C of C is required	

*W 14.05.21*

120	Receive & Inspect for Damage & Mat'l Certs	0.00
*120*		
Packaging	Memo	0.00
Packaging	Ensure C of C is attach	

*PE/5/22 (10)*

130	QC6- Inspect dimensions to drawing	0.00	DAS 27 9-89
*130*			
QC	Memo	0.00	<i>14/5/22</i>
Quality Control			

*10*

*inspect as per  
Dwg PE1*

Work Order ID 119740

May-21-14 9:18:59 AM

\*119740\*

Page 2

Item ID: D3910-7 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: PRELIM Stop \*NS2\*  
Item Name: Crosstube Lug  
Start Date: 5/21/14 Start Qty: 10.00 \*10\* Cust Item ID:  
Required Date: 5/22/14 Req'd Qty: 10.00 \*10\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140	Chemical Conversion Coat per QSI005 4.1	0.00				10	7/14/5-23		
*140*	HandFinish	0.00							
	Hand Finishing								

150	QC7-Inspect Chemical Conversion Coat	0.00				10	14-5-23		DAS 34 9-89
*150*	QC	0.00							
	Quality Control								

160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				10	14-5-23		DAS 34 9-89
*160*	Powdercoat	0.00							
	Powder Coating								

Memo  
START TIME: 845.  
OVEN TEMPERATURE: 320.  
FINISH TIME: 9.15.

Work Order ID 119740

\*119740\*

Page 3

May-21-14 9:18:59 AM

Item ID: D3910-7 Accept \*N900040100\* Setup Start \*NS1\*  
Revision ID: PRELIM Stop \*NS2\*  
Item Name: Crosstube Lug  
Start Date: 5/21/14 Start Qty: 10.00 \*10\* Cust Item ID:  
Required Date: 5/22/14 Req'd Qty: 10.00 \*10\* Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170 *170* QC Quality Control	QC3- Inspect Part Finish  Memo	0.00 0.00				10			
						Inspector for Durs PEI			
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo	0.00 0.00							
									Reinspect. to Rev E Dwg 5/14/09
190 *190* QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							
						MLJ	14-06-10		

POSITIVE RECALL  
EFFECTIVE 4/05/22  
RELEASED 5 AUTH 1/2  
DATE 4/06/09  
to Rev E Dwg.

mf  
14-5-23

May-21-14 9:18:58 AM

**Work Order ID:** 119740

**\*119740\***

**Parent Item:** D3910-7

**\*D3910-7\***

**Parent Item Name:** Crosstube Lug

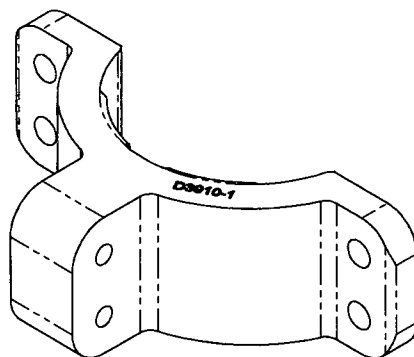
**Start Date:** 5/21/14**Required Date:** 5/22/14

**Start Qty: 10.00**

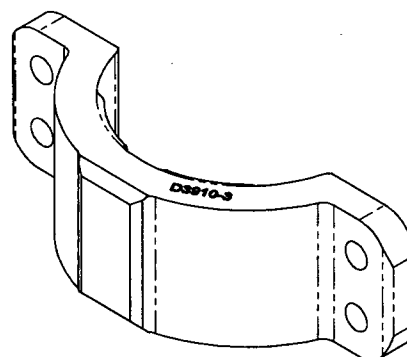
**Required Qty: 10.00**

**Comments:** IPP REV:A 14.05.21 NEW ISSUE DD VERF:JFS

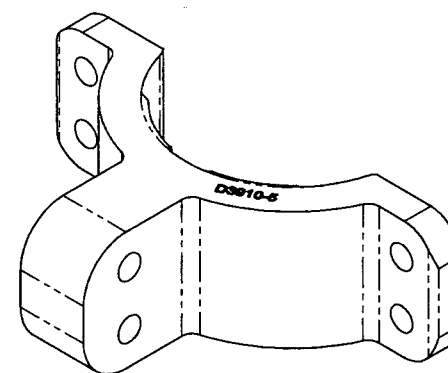
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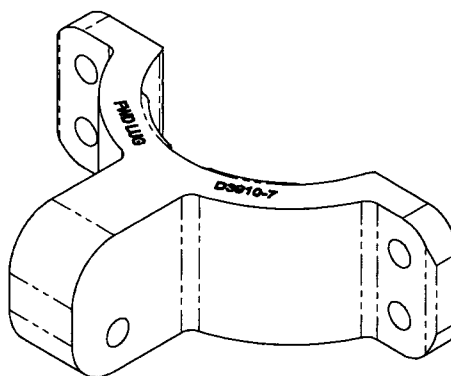
**D3910-1 X-TUBE LUG**



**D3910-3 X-TUBE LUG**



**D3910-5 X-TUBE LUG**



**D3910-7 X-TUBE LUG**

also  
119746

PRELIMINARY E1  
14.05.16 AJS

**NOTES:**

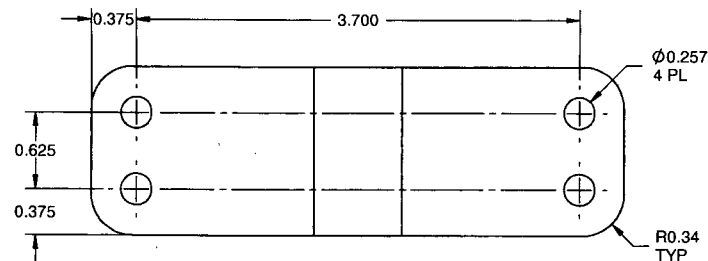
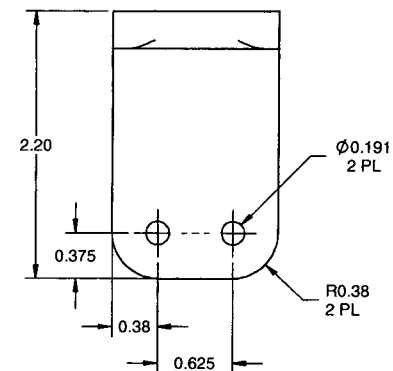
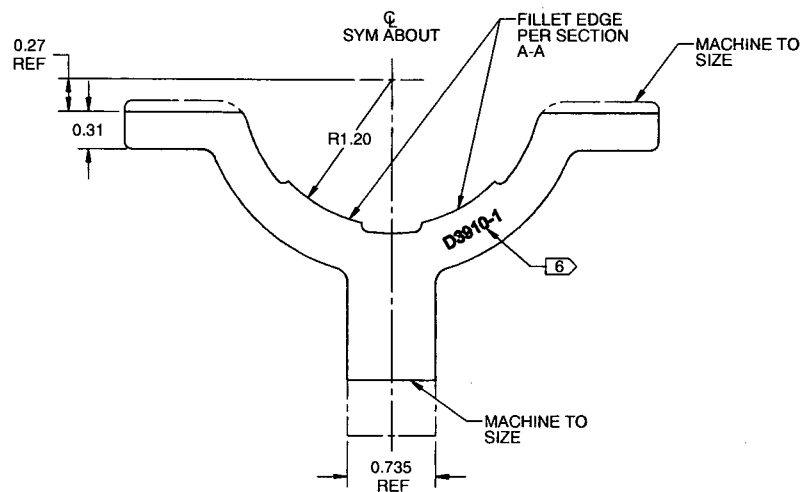
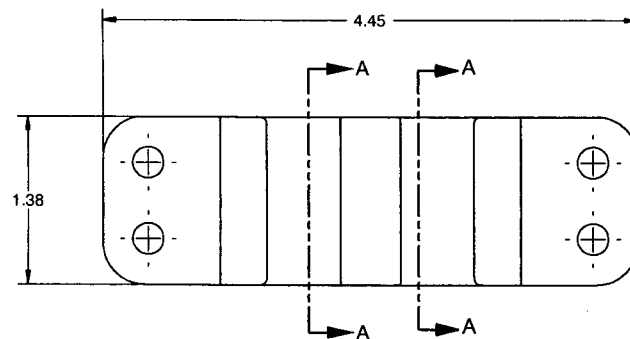
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010  $\pm$  0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015  $\pm$  0.005
- 7) WEIGHT -1: 0.32 lbs  
-3: 0.25 lbs  
-5: 0.36 lbs  
-7: 0.37 lbs
- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010  $\pm$  0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015  $\pm$  0.005

PE1	PRELIM: ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø 0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D390-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3910	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	14.05.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL

**SECTION A-A**



**D3910-1 X-TUBE LUG**

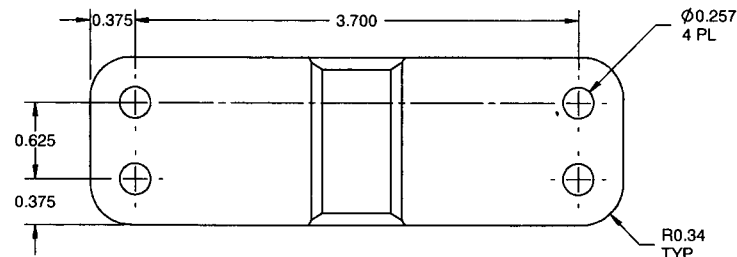
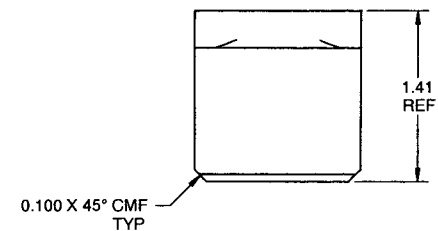
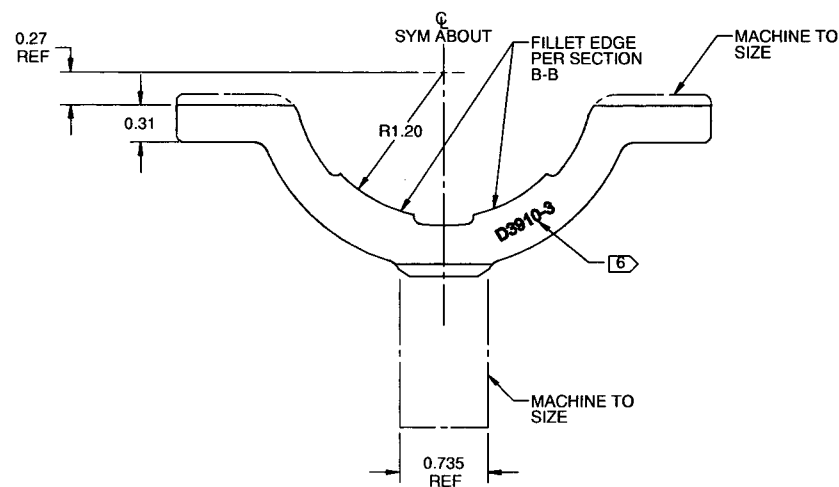
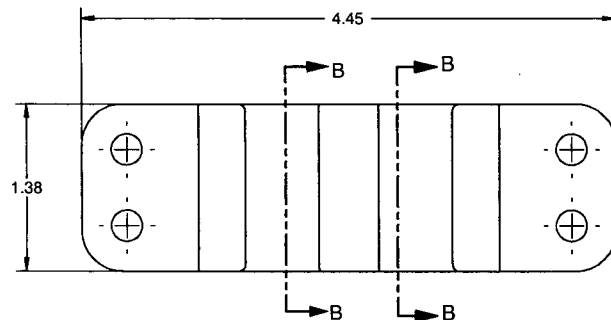
**PRELIMINARY E1**  
14.05.16 AJS

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3910	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
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ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL

**SECTION B-B**



**D3910-3 X-TUBE LUG**

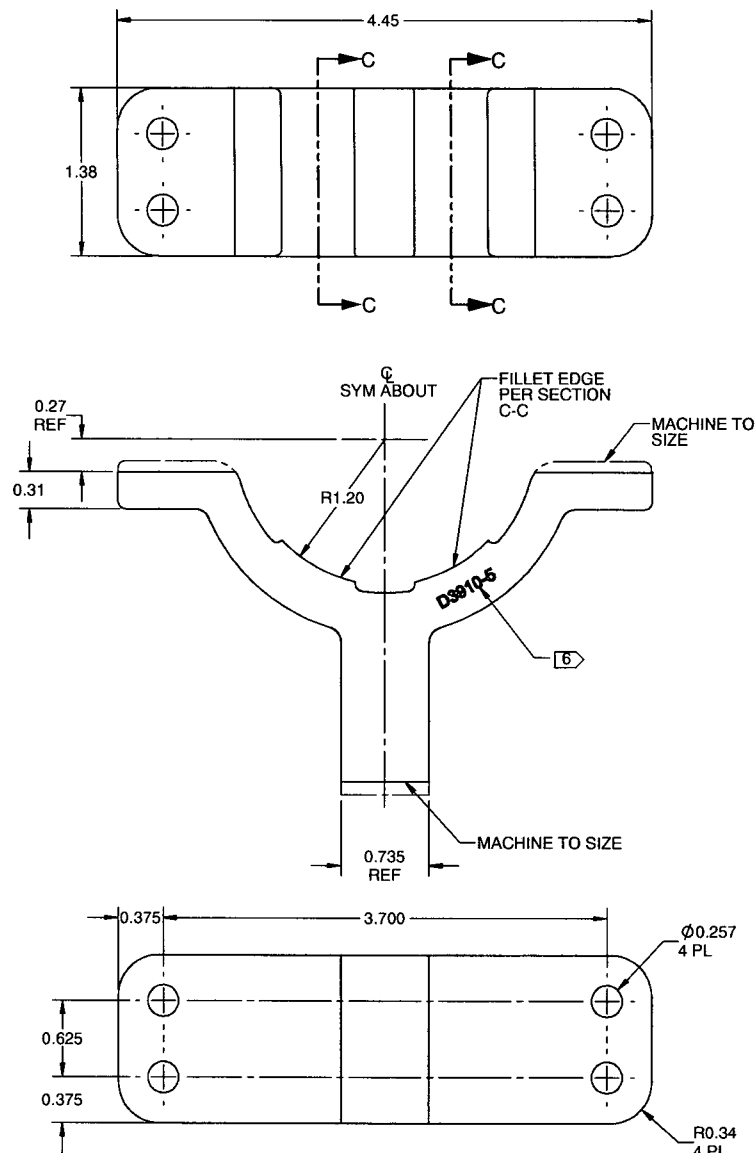
**PRELIMINARY E1**  
14.05.16 AJS

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. <b>D3910</b>	REV. PE1 SHEET 3 OF 5
MFG. APPR.		TITLE	SCALE
APPROVED		<b>X-TUBE LUG (350)</b>	
DE APPR.		NTS	
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

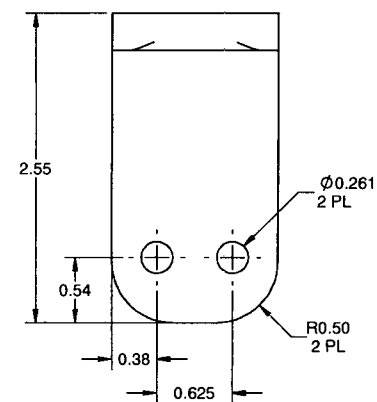
# SECTION C-C



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-5 X-TUBE LUG**



**PRELIMINARY E1**  
14.05.16 AJS

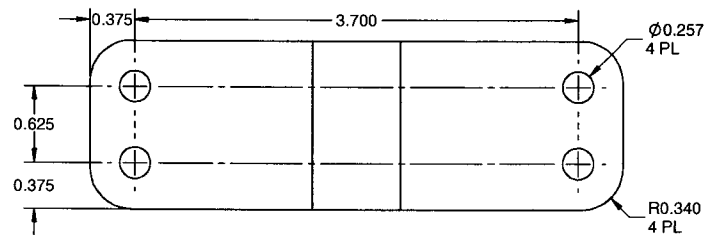
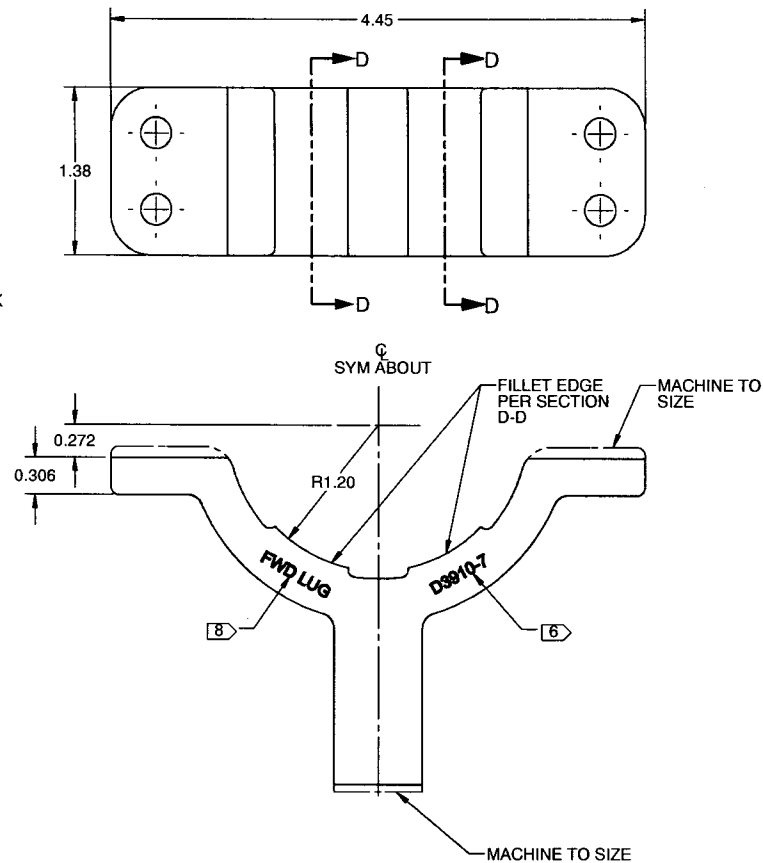
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		<b>D3910</b>	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>X-TUBE LUG (350)</b>	NTS
DATE	<b>14.05.16</b>	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



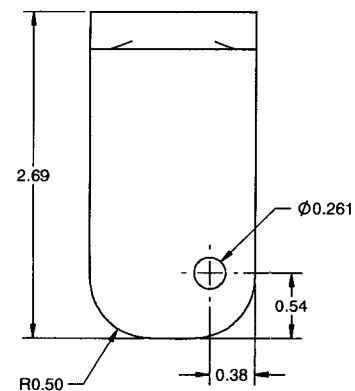
**SECTION D-D**



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-7 X-TUBE LUG**



**PRELIMINARY E1**  
14.05.16 AJS

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PE1
MFG. APPR.		D3910	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED FOR DISSEMINATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO24278**

Purchase Order Date 5/21/2014

PO Print Date 5/21/2014

Page Number 1 of 2

**Order From :**

METEC METAL TECHNOLOGY INC.  
20 TERRY FOX DRIVE PO BOX 781  
VANKLEEK HILL, ON K0B 1R0  
CA

VC-MET003

**Ship To :** DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Linda Lacelle

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3910-7P  PER DRWG D3910 PE1	Crosstube Lug	5/21/2014 Yes 5/22/2014		10.00 Each	\$31.55	\$315.50
						Line Total:	\$315.50
2	D3910-7P  PER DRWG D3910 REV.PE1 ***DO NOT PRODUCE THESE 60 UNTIL WE TRIAL FIT THE FIRST 10...TBA BY FRIDAY 23/05***	Crosstube Lug	5/21/2014 Yes 5/27/2014		60.00 Each	\$31.55	\$1,893.00
						Line Total:	\$1,893.00

**PO Instructions:**

Note:

5/21/2014



20 Terry Fox Drive  
Vankleek Hill, Ontario K0B 1R0 , Canada  
Tel: (613) 678-3957  
Fax: (613) 678-3956

**Delivery Slip No.:** 20002  
**Date:** May 22, 2014  
**Page:** 1

<b>Sold to:</b>	<b>Ship to:</b>
<b>Dart Aerospace Ltd.</b> Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
<b>Order No.:</b> 24278	<b>Sold By:</b> Dewar, Eric
<b>Shipped By:</b> your truck	<b>Ship Date:</b> May 22, 2014

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
3910-7 Crosstube Lug, as per drawing D3910 PE1	Each	10	10	
3910-7 Crosstube Lug, as per drawing D3910 REV. PE1 Trial fitting the first 10 before the 60 are produced	Each	60		60
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 [metec@metec.ca](mailto:metec@metec.ca)

---

## CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, Ont.  
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
10	D3910-7 PE1	Crosstube Lug	24278

MATERIAL: supplied by DART B105422

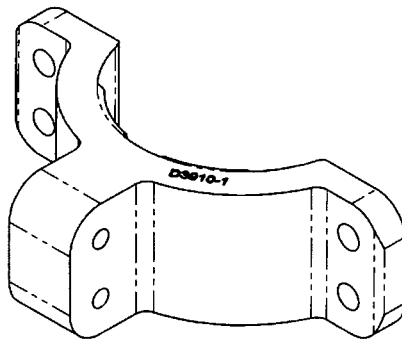
We hereby certify that the above parts were made in conformance with applicable drawings.

*METEC Metal Technology Inc.*

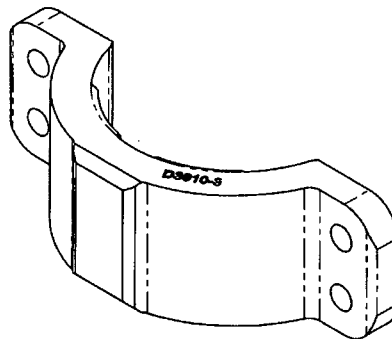
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Jan Norris

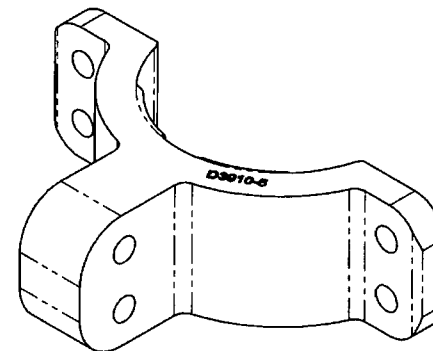
Vankleek Hill, May 22 2014



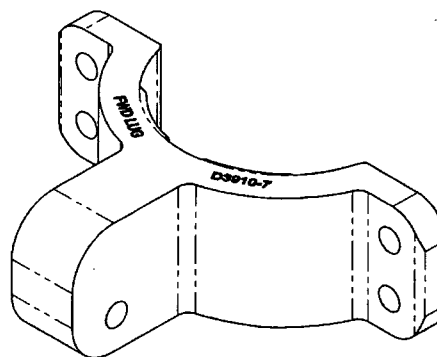
**D3910-1 X-TUBE LUG**



**D3910-3 X-TUBE LUG**



**D3910-5 X-TUBE LUG**



**D3910-7 X-TUBE LUG**

**NOTES:**

- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010  $\pm$  0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015  $\pm$  0.005
- 7) WEIGHT -1: 0.32 lbs  
-3: 0.25 lbs  
-5: 0.36 lbs  
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- 8) IDENTIFICATION: ENGRAVE "FWD LUG" TO A DEPTH OF 0.010  $\pm$  0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015  $\pm$  0.005

**RELEASED**

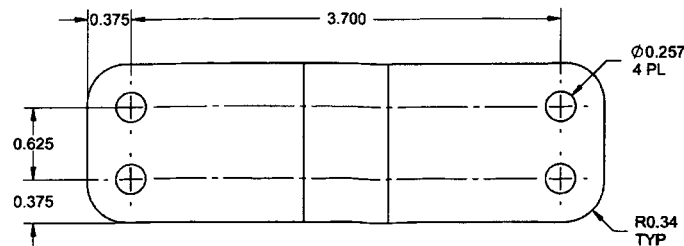
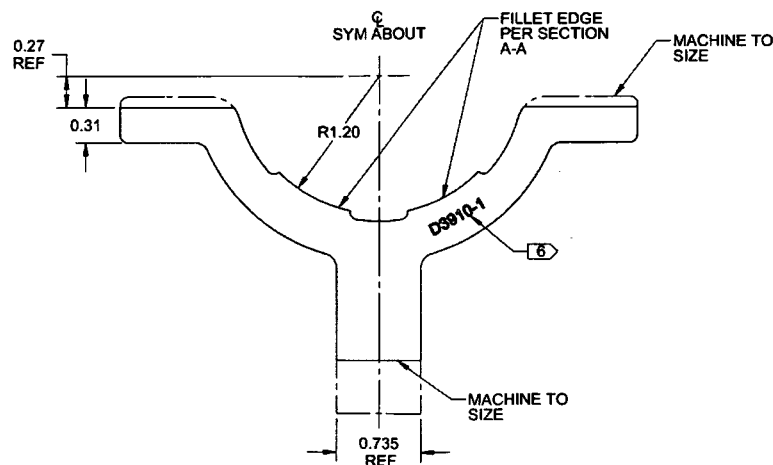
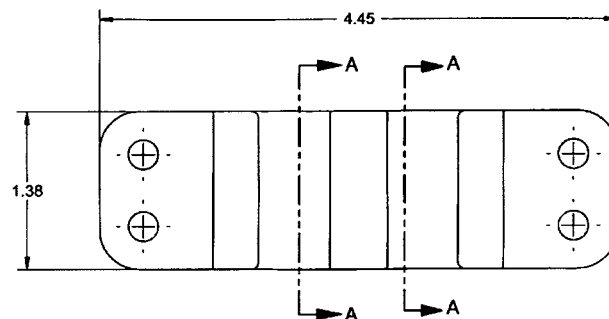
2016 JUN 05  
ECN 14-572

E	ADD -7 PER NCR14-3871	AJS	14.05.16
D	CHANGED FASTENER HOLES IN -5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD -5.	AJS	13.08.08
B	Ø 0.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.34 FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-0350-807-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 1 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	14.05.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

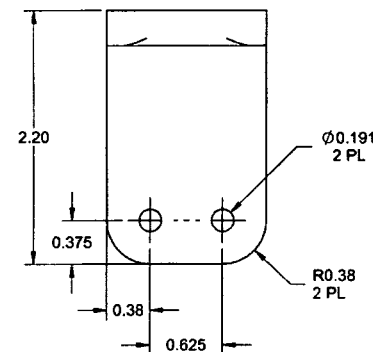


ROUND EDGE  
R0.06 MIN - R0.10 MAX  
2 PL

**SECTION A-A**







**D3910-1 X-TUBE LUG**



**RELEASED**

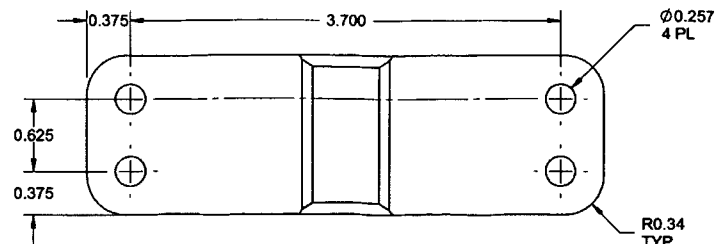
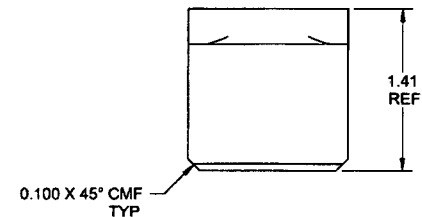
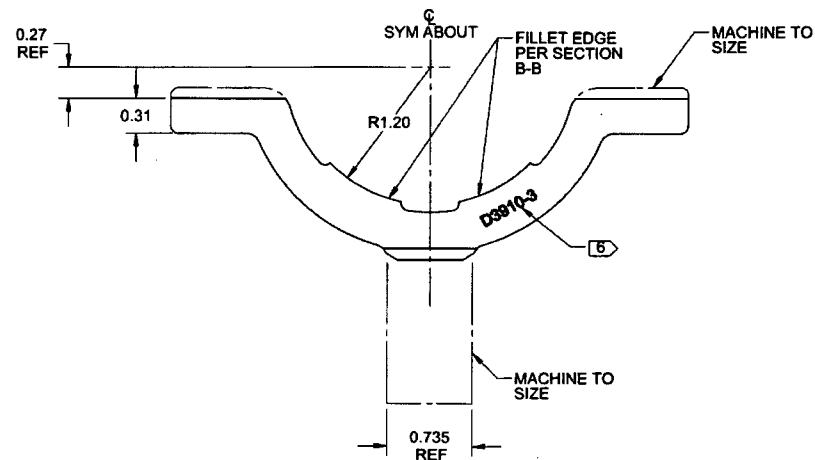
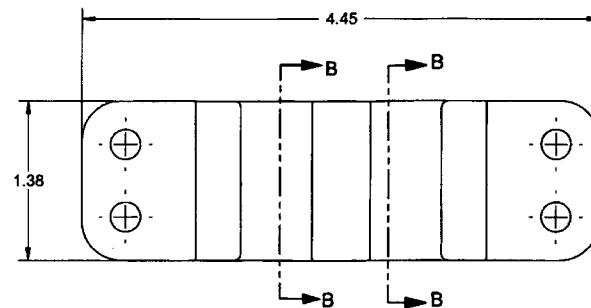
2014 JUN 05 *dp*

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3910	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		X-TUBE LUG (350)	NTS
DATE	14.05.16	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**SECTION B-B**



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-3 X-TUBE LUG**

**RELEASED**

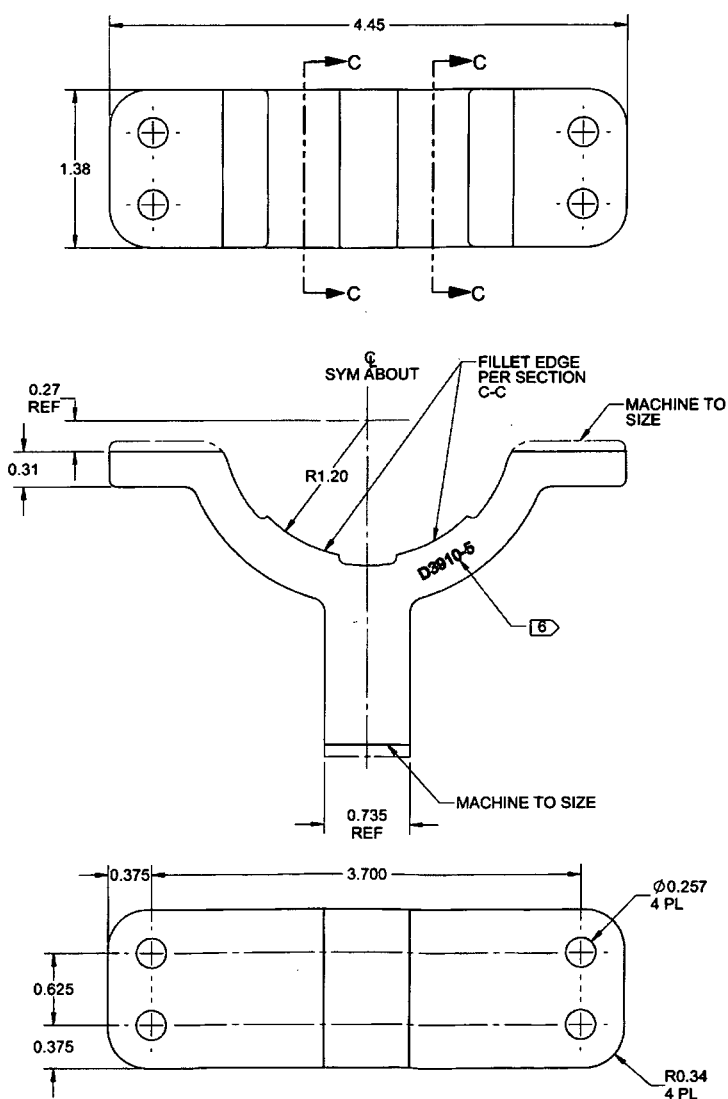
2014 JUN 05

DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 3 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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**SECTION C-C**



ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-5 X-TUBE LUG**

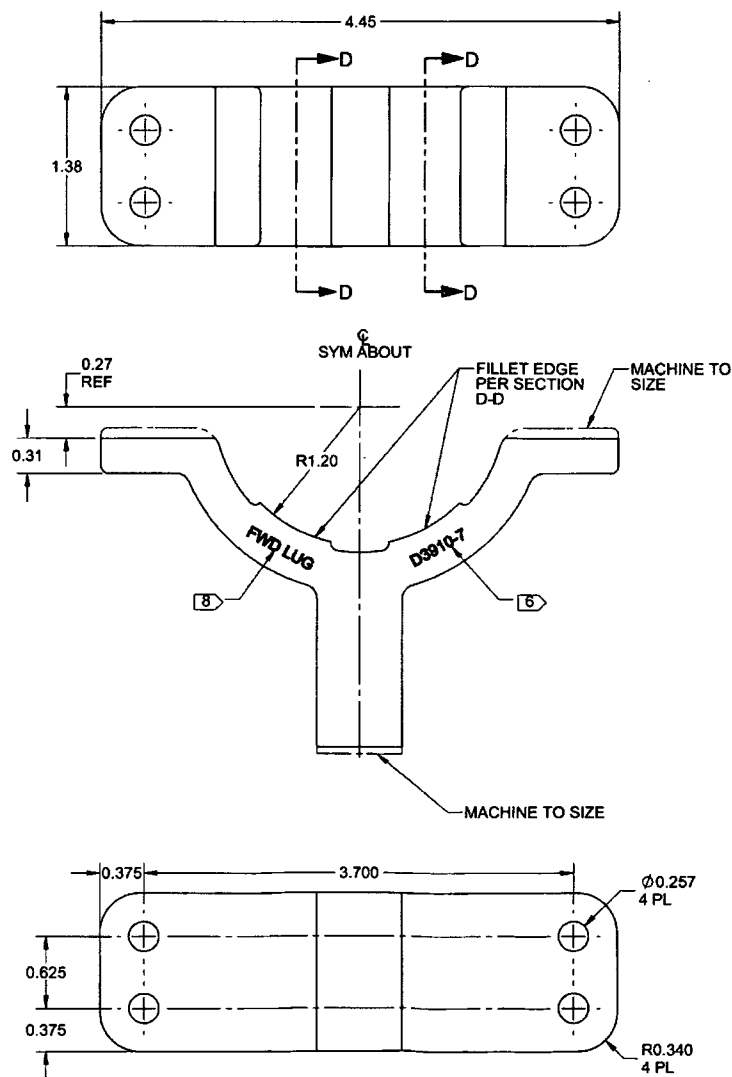
**RELEASED**  
2014 JUN 05

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DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO. <b>D3910</b>	REV. E
MFG. APPR.	<i>[Signature]</i>	TITLE <b>X-TUBE LUG (350)</b>	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	SCALE <b>NTS</b>	
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DATE	14.05.16		

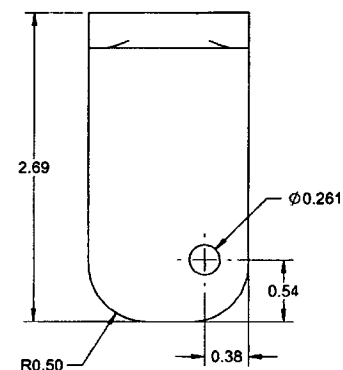




—ROUND EDGE  
R0.06 MIN - 0.10 MAX  
2 PL



**D3910-7 X-TUBE LUG**



**RELEASED**

2014 JUN 05 *gf*

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DRAWN	AJS		SHEET 5 OF 5
CHECKED	<i>[Signature]</i>		SCALE
MFG. APPR.	<i>[Signature]</i>		NTS
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	14.05.16		